

Date: Tuesday, 11/13/2007 1:26:52 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 35664	
Estimate Number : 13010	
P.O. Number : <u>N/A</u>	Part Number : D3245043
This Issue : 11/13/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3245 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 34553	Material : <u>N/A</u>
Written By : _____	Due Date : 12/10/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev : A New Issue 07-09-11 JLM Verified By: EC	
Est Rev: b ECN 1052 07-10-31 DD verified by:	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D32453	Door
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Door  
 Batch: B 35693

mf 07-11-30

3.0	D32457	Gasket
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 Gasket  
 Batch: B 35668

mf 07-11-30

4.0	235120009C3Y	STUD
-----	--------------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)  
 STUD  
 Batch: M106198

x 47 mx, M106484 x 17 mx mf 07-11-30

5.0	127H35	HALF GROMMET
-----	--------	--------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)  
 HALF GROMMET  
 Batch: M18245

mf 07-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/12/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/13/2007 1:26:52 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 35664

Part Number: D3245043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Studs and Gromets as per Dwg D3245

3-Bond Gasket using 3M ADHESIVE as per Dwg D3245

A/R 3M 1300/1300L ADHESIVE

Batch: M102890

mf

0711-30 (8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

U 11/11/12 (8)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock

Location: ST 183

U AS 04/12/12

(8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

U 04/12/12

Job Completion



U 07/12/12

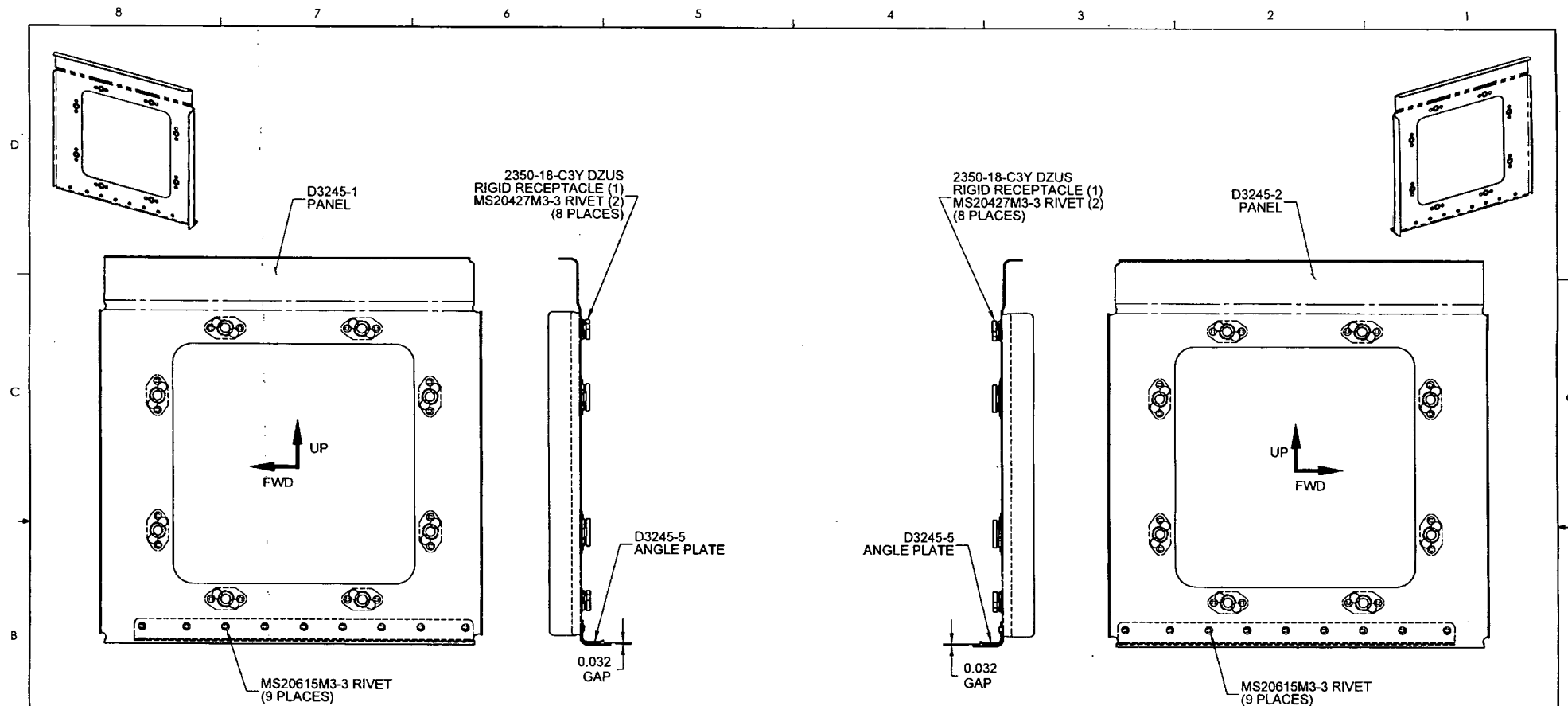
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3245-041 ACCESS PANEL ASSEMBLY**

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

**D3245-042 ACCESS PANEL ASSEMBLY**

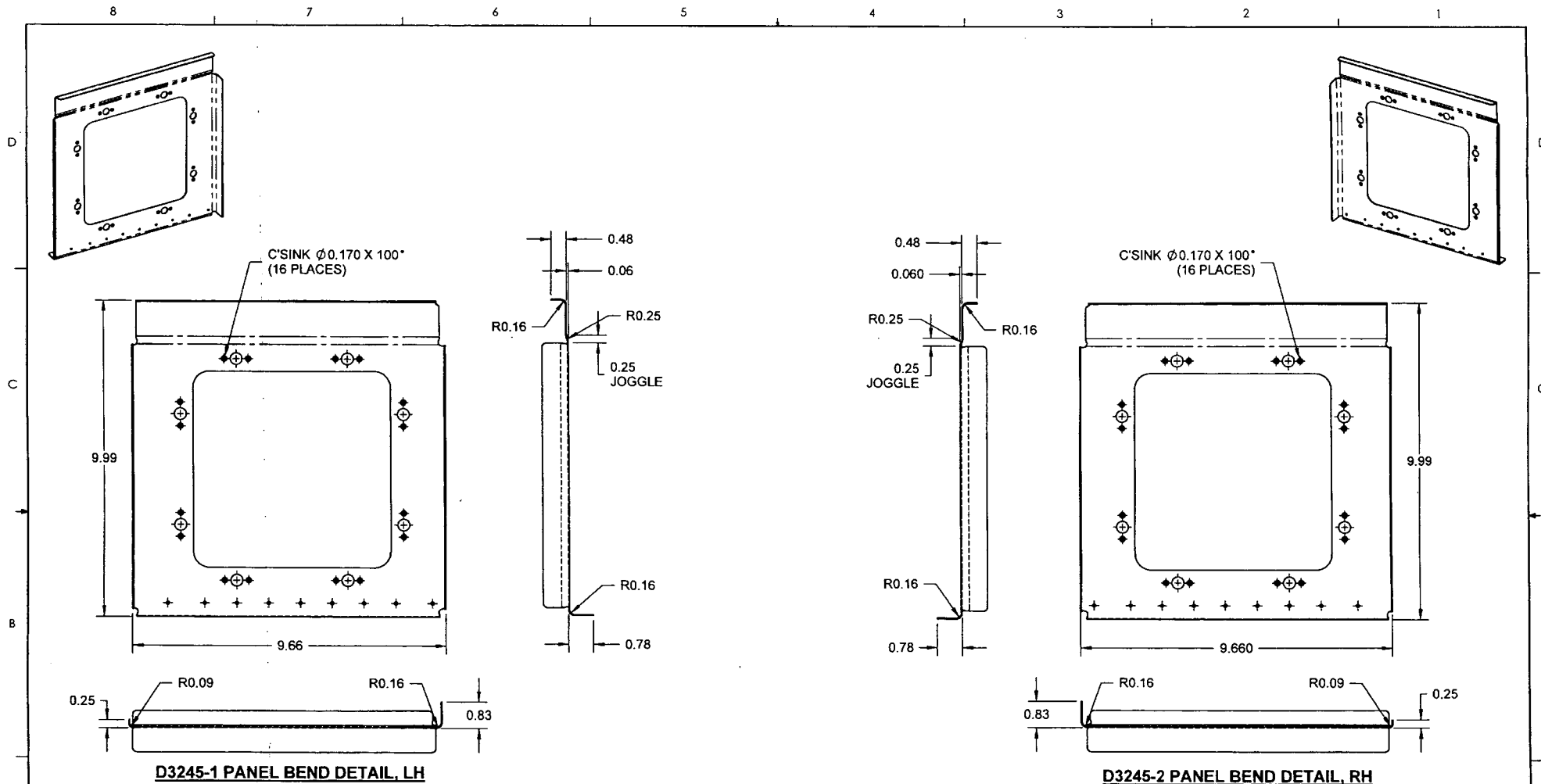
B	REMOVE Ø0.204 HOLES FROM D3245-1/1F. REMOVE MS21060-L3K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3245	SHEET 1 OF 7
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY	
DE APPR.	<i>[Signature]</i>	1:2.5	
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
07-10-23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

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WORK ORDER  
SUBJECT TO AMENDMENT  
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D3245-1 PANEL BEND DETAIL, LH

D3245-2 PANEL BEND DETAIL, RH

RELEASED  
07-10-23

NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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DRAWN	<del>TH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	<del>IS</del>	SHEET 2 OF 7	
APPROVED	<del>TH</del>	TITLE	SCALE
DE APPR.	<del>TH</del>	<b>ACCESS PANEL ASSEMBLY</b>	
DATE	07.10.02	1:3	

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DART

8 7 6 5 4 3 2 1

D3245-5 DOOR  
2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)

D3245-7 GASKET (REF)  
8.00  
(TYP, REF)

# **D3245-043 DOOR ASSEMBLY**

INSTALL D3245-7  
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

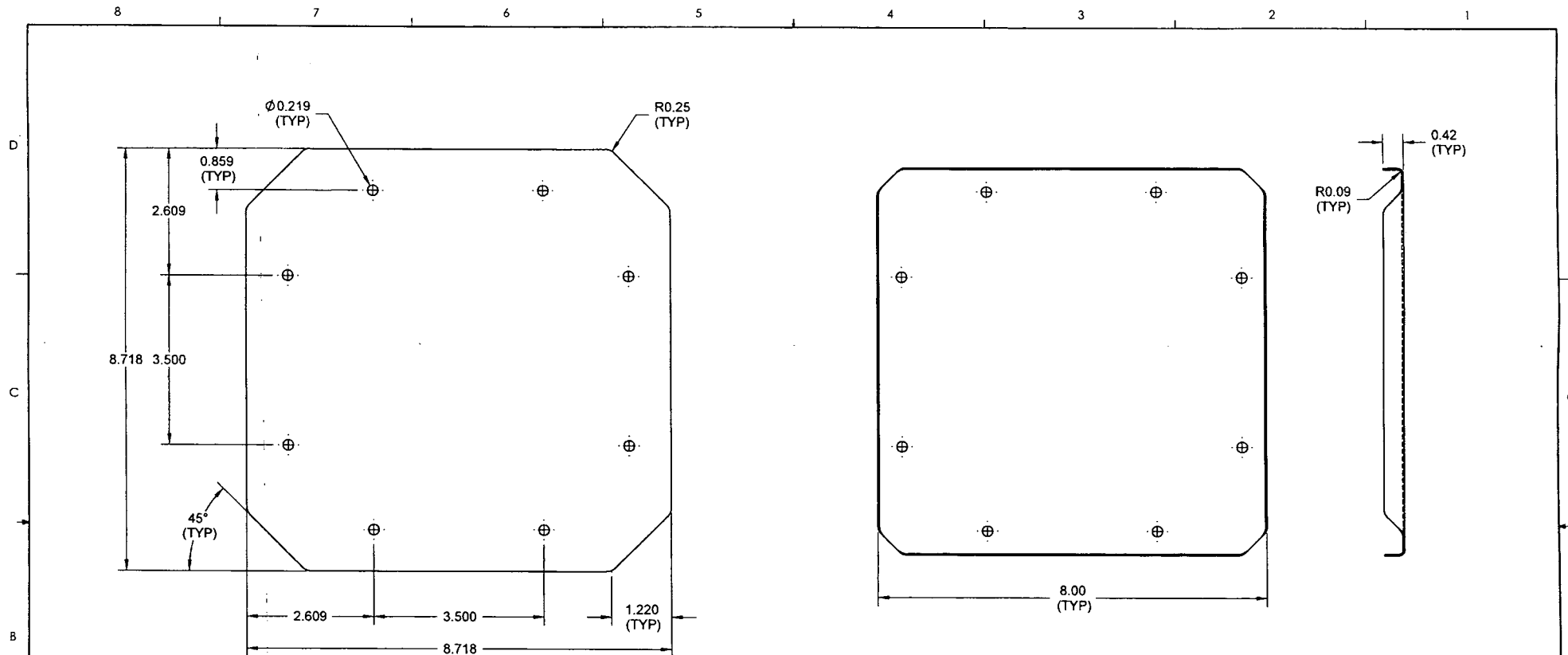
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DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3245 SHEET 3 OF 7
APPROVED		TITLE SCALE
DE APPR.		ACCESS PANEL ASSEMBLY 12
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7/27/03

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7 6 5 4 3 2 1





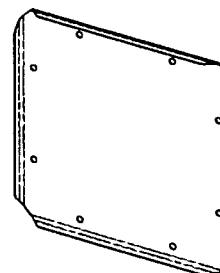
**D3245-3F DOOR FLAT PATTERN**

**D3245-3 DOOR BENDING DETAIL**

**RELEASED**  
07-10-02

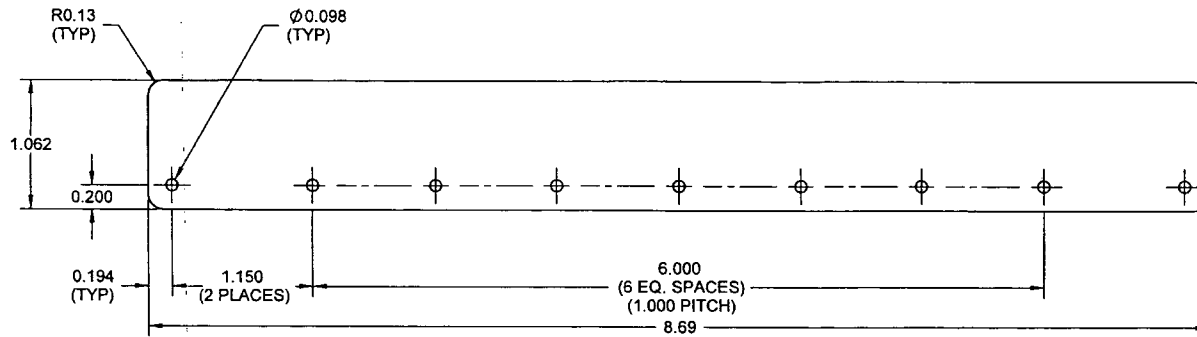
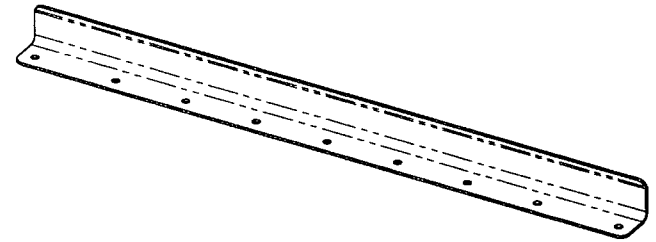
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.67 lbs

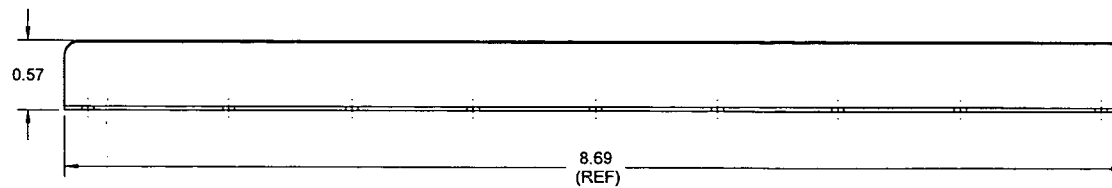


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DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3245	SHEET 5 OF 7
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>ACCESS PANEL ASSEMBLY</b>	
DATE	07.10.02	1:2	
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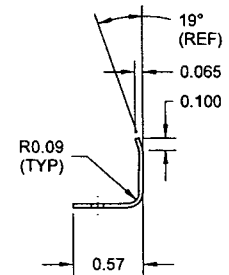
8 7 6 5 4 3 2 1



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL**  
(MAKE FROM D3245-5F)



**RELEASED**  
07.10.13

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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MFG. APPR.	<del>PH</del>	D3245	SHEET 6 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	ACCESS PANEL ASSEMBLY	1:1
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8

7

6

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4

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2

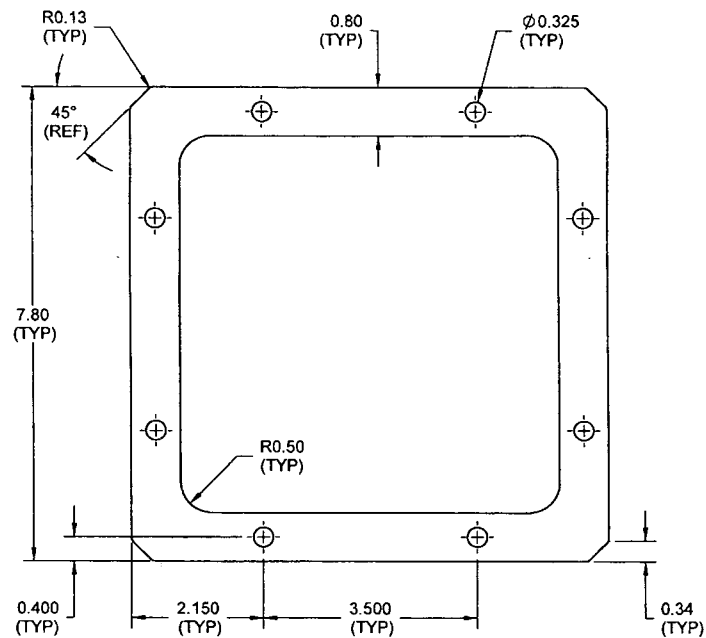
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A

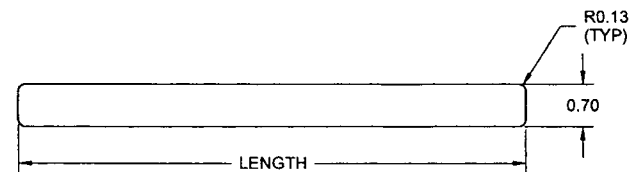
B

C

D



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	<del>JS</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>JS</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>JS</del>	D3245	SHEET 7 OF 7
APPROVED	<del>JS</del>	TITLE	SCALE
DE APPR.	<del>JS</del>	<b>ACCESS PANEL ASSEMBLY</b>	
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